

Work Order ID 69440

Wednesday, May 11, 2011 10:17:23 AM



Page 1

Item ID: D3811-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Seat Track Assembly

Start Date: 5/11/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 5/12/2011 Req'd Qty: 2.00

Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3811	Rev A								

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-Install BUSHINGS AS PER DWG D3811 TORQUING TO 20-25 IN LBS.

[Signature] 5/11/11 (2)

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

[Signature]

[Signature]

120

Identify as per dwg & Stock Location:

963

0.00



Packaging

Memo

0.00

Packaging

11/5/11 sl (2)

Work Order ID 69440

Wednesday, May 11, 2011 10:17:23 AM

Page 2

Item ID: D3811-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Seat Track Assembly

Start Date: 5/11/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 5/12/2011 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21 - Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/5/13
ME
11-05-12




Wednesday, May 11, 2011 10:17:20 AM

Page 1



Required Date: 5/12/2011

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3811-1  Seat Track		Manufactured	No			100	Each	3.0000	1	2		05/11/11	
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST263			3			2			
					44834		3						
D3811-3  Bushing		Manufactured	No			100	Each	81.0000	4	8		05/11/11	
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST084			81			8			
					44040		21						
					44348		60						
MS21042L3  Nut		Purchased	No			100	Each	2,355.000	2	4		05/11/11	
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST300			2355						
					116391		11						
					116540		378			4			
					116549		766						
					117441		800						
					117601		400						

Picklist Print

Wednesday, May 11, 2011 10:17:21 AM

Page 2

Work Order ID: 69440

Parent Item: D3811-041

Parent Item Name: Seat Track Assembly



Start Date: 5/11/2011

Required Date: 5/12/2011

Start Qty: 2.00

Required Qty: 2.00

MS27039-1-15

Purchased

No

100

Each

100.0000

2

4



Screw



EPB/05/11

Location

Loc Qty

Loc Code

ST292

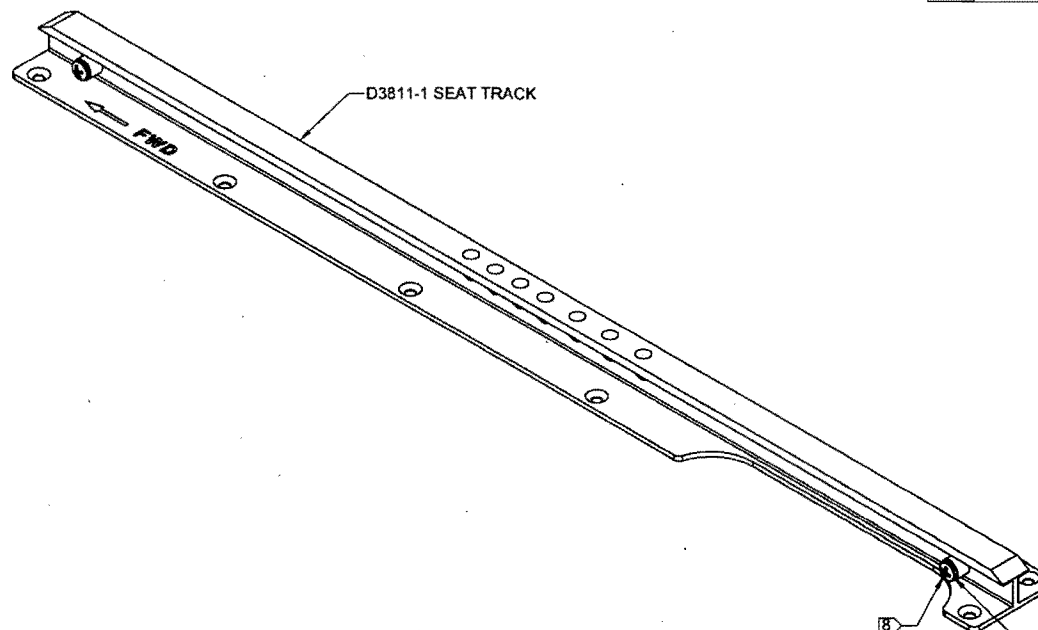
100

116916

100

4

QTY	P/N	DESCRIPTION
-041		
X	D3811-041	SEAT TRACK ASSEMBLY
1	D3811-1	SEAT TRACK
4	D3811-3	BUSHING
2	MS21042L3	NUT
2	MS27039-1-15	SCREW



D3811-041 SEAT TRACK ASSEMBLY

RELEASED
08-08-18

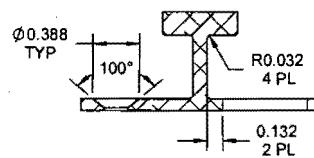
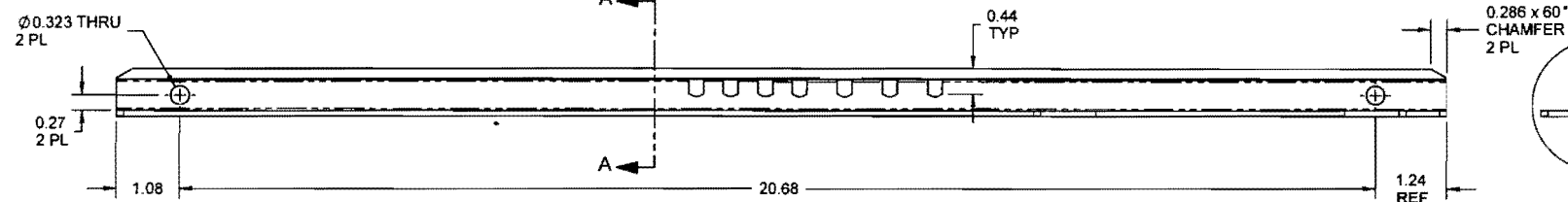
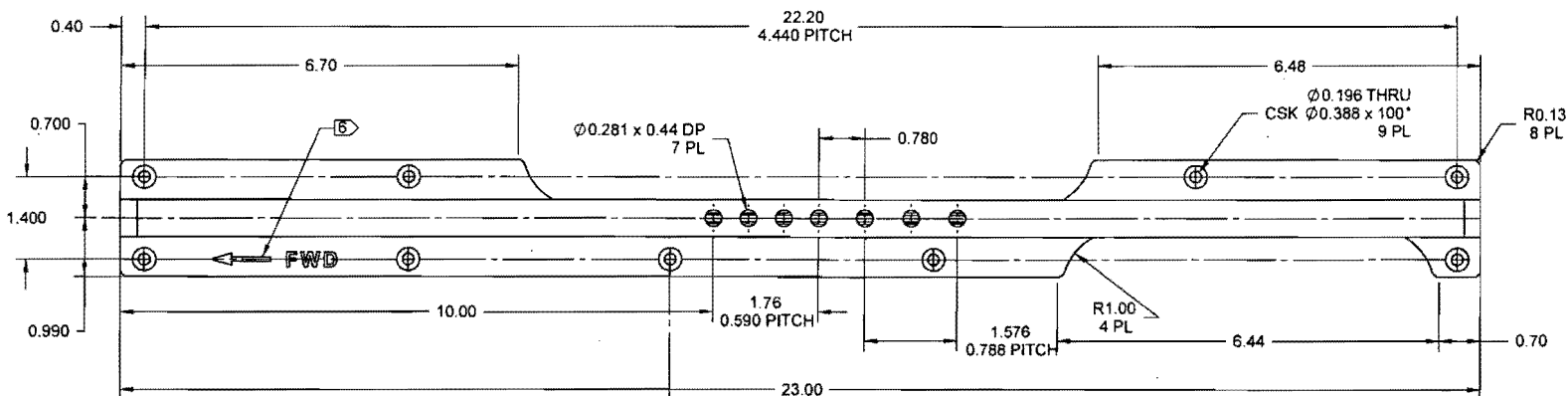
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N D3811-041 & B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.76 lbs
- 8) TORQUE FASTENERS TO 20-25 in-lbs

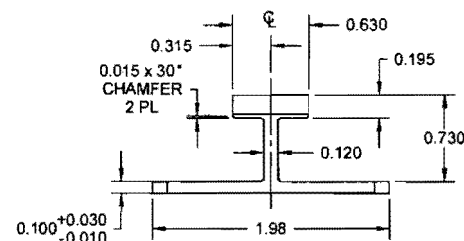
W1069440

A NEW ISSUE		RF	08.08.18
REV.	DESCRIPTION		BY DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3811	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		SEAT TRACK ASSEMBLY	NTS
DATE		COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. NO DISSEMINATION OR REPRODUCTION OF THIS DOCUMENT IS PERMITTED WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
08.08.18			

8 7 6 5 4 3 2 1



SECTION A-A



DETAIL B

D3811-1 SEAT TRACK

RELEASED
06-09-2010

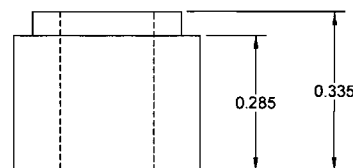
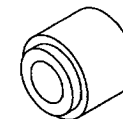
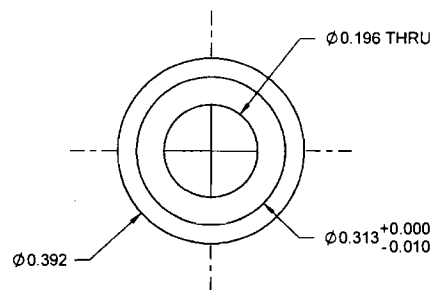
NOTES:

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR PER AMS-QQ-A-200/8 (OR AMS 4160) OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) (REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE ARROW & FWD AS SHOWN USING 0.25 HIGH LETTERS TO MAX DEPTH OF 0.005
- 7) WEIGHT: 0.724 lbs

69440

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO. D3811	REV. A
MFG. APPR.		TITLE SEAT TRACK ASSEMBLY	SHEET 2 OF 3
APPROVED		SCALE NTS	
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DATE	08.08.18		

8 7 6 5 4 3 2 1



D3811-3 BUSHING

69440

RELEASED
68-09-50112

NOTES:

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM ROUND BAR PER AMS-QQ-A-200/8 (OR AMS 4163) OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) (DART REF. SPEC. M6061T6R)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.003 lbs

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DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3811	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		SEAT TRACK ASSEMBLY	NTS
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